



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3556-1
Job Sheet 191882



Part No: D3556-1

Job Qty: 24 pcs

Part Name: R44 Bearpaw Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 5/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP Rev:A New Issue 07-03-23 JLM IPP Rev:B 08-07-28 per dwg revb (ecn 08-506) DD verified by:EC IPP Rev C 11.07.14 now in-house EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	24 pcs		5/28/19	0.00	0.91	Waterjet - Flow		OK 19/05/30
120	QC 8	24 pcs		5/28/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - Brake NC - B4B	24 pcs		5/28/19	0.01	0.40	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 -		

140 QC 5	24 pcs	5/28/19	0.00 0.00	B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
					DAS 40
					JUN 06 2019 9-8
150 Packaging 3-1 - Stock - B4B	24 pcs	5/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST 542
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	24 pcs	5/28/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 130 - (Form as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.9120 sf (.038 ea)	100-Waterjet - Flow - 1	S159674

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	358	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.375inches ± 0.010	0.385 0.365		
2	Clamp	0.450inches ± 0.010	0.460 0.440		
3	Clamp	0.750inches ± 0.030	0.780 0.720		
4	Clamp	1.000inches ± 0.030	1.030 0.970		
5	Clamp	7.130inches ± 0.030	7.160 7.100		
6	Clamp	0.257inches + 0.005 - 0.001	0.262 0.256		
7	Clamp	0.375inches ± 0.010	0.385 0.365		
8	Clamp	6.226inches ± 0.030	6.256 6.196		
9	Clamp	0.063inches ± 0.010	0.073 0.053		

Plex 5/30/19 10:35 AM Dart.Hadley.Shannon



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D3556-1
Job Sheet 191882



Part No: D3556-1

Job Qty: 24 ea

Part Name: R44 Bearpaw Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 4/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 07-03-23 JLM IPP Rev:B 08-07-28 per dwg revb (ecn 08-506) DD verified by:EC IPP Rev C 11.07.14 now in-house EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	24 pcs		4/8/19	0.00	0.91	Waterjet - Flow		
120	QC	24 pcs		4/8/19	0.00	0.00	QC8		
130	Brake NC	24 pcs		4/8/19	0.01	0.40	Brake NC 1		
140	QC	24 pcs		4/8/19	0.00	0.00	QC5		
150	Packaging	24 pcs		4/8/19	0.00	0.00	Packaging3		
160	QC21-SA	24 Ea		4/8/19	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.9120 sf (.038 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	317	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.375inches $\pm$ 0.010	0.385 0.365		
2	Clamp	0.450inches $\pm$ 0.010	0.460 0.440		
3	Clamp	0.750inches $\pm$ 0.030	0.780 0.720		
4	Clamp	1.000inches $\pm$ 0.030	1.030 0.970		
5	Clamp	7.130inches $\pm$ 0.030	7.160 7.100		
6	Clamp	0.257inches + 0.005 - 0.001	0.262 0.256		
7	Clamp	0.375inches $\pm$ 0.010	0.385 0.365		
8	Clamp	6.226inches $\pm$ 0.030	6.256 6.196		
9	Clamp	0.063inches $\pm$ 0.010	0.073 0.053		

Plex 3/11/19 2:47 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S185565



Part: D3556-1

Job No: 191882

Serial No/Batch: S185565

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 05/30/19